

Date: Monday, 27/04/2009 12:51:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 47525	
Estimate Number : 12729	
P.O. Number :	Part Number : D353539 64
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 44645	Material :
Written By :	Due Date : 04/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.04.27</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.9986 sf(s)/Unit Total : 9.9855 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 111571 IB 9-5-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B IB 9-5-20
 Prog Rev: B
 2-Deburr if necessary IB 9-5-20

(13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 09/05/21

(13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 Identify as D3535-41

SB 09/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:51:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 47525

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle on brake using Jig DT8158 as per Dwg D3535

SB 09/05/22

(13)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/22 (X13)

7.0

POWDER COATING

POWDER COATING



11109091



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 8:45am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:15am

1/P

09-05-25 (X13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

UMP / FZ

09/05/25 (X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR-18

UMP 09/05/25

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



MF 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47525
Description: Wearshoe		Part Number: D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	✓			
32.775	+/-0.010	32.775	✓			
29.275	+/-0.010	29.275	✓			
25.775	+/-0.010	25.775	✓			
23.250	+/-0.010	23.250	✓			
19.750	+/-0.010	19.750	✓			
17.750	+/-0.010	17.750	✓			
14.250	+/-0.010	14.250	✓			
9.500	+/-0.010	9.500	✓			
4.750	+/-0.010	4.750	✓			
2.000	+/-0.010	2.000	✓			
5.00	+/-0.030	5.00	✓			
9.00	+/-0.030	9.00	✓			
28.00	+/-0.030	28.00	✓			
Ø0.188	+0.005/-0.001	.192	✓			
1.885	+/-0.010	1.886	✓			
0.300	+/-0.010	3.002	✓			
0.300	+/-0.010	3.004	✓			
0.038	+/-0.010	.040	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-20	Date: 09/05/21	Date:	N/A

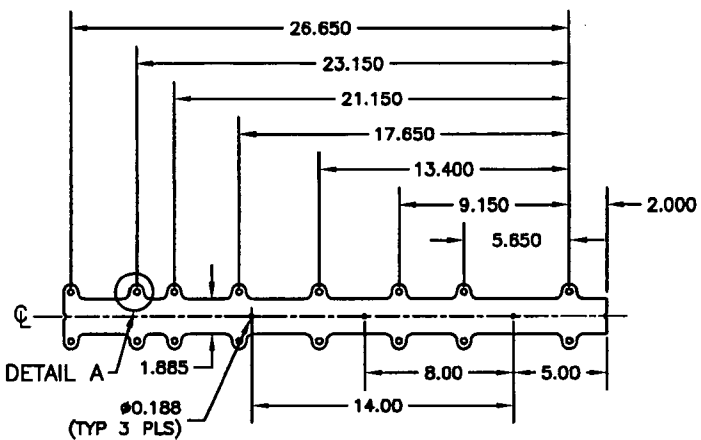
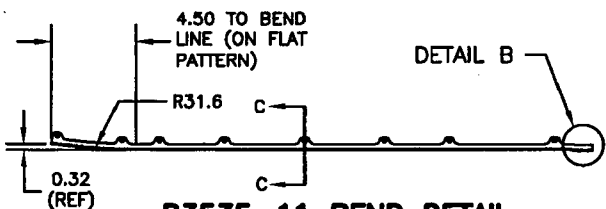
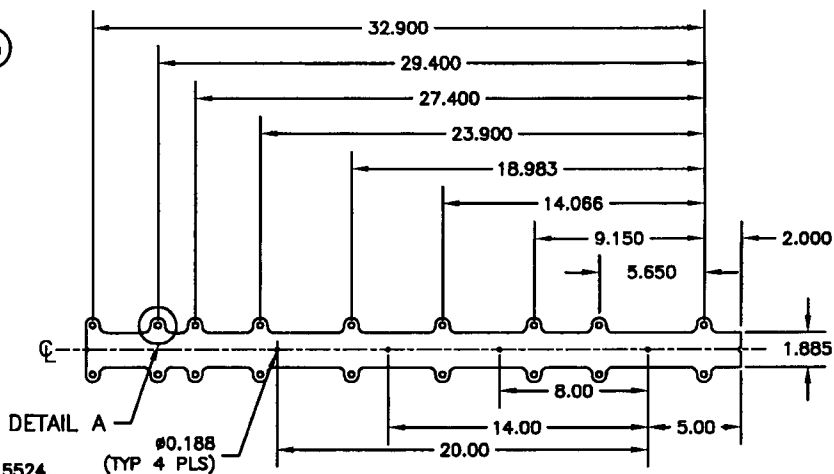
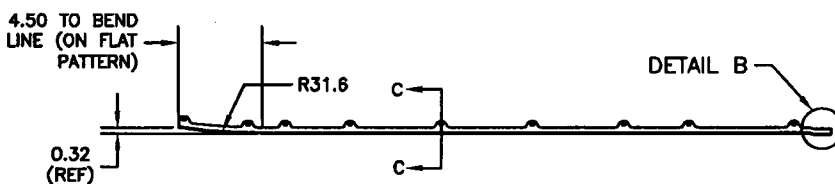
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

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07.04.24

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
PH	PH	D3535	SCALE
DATE	TITLE	WEARSHOE	1:10
07.04.17			
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

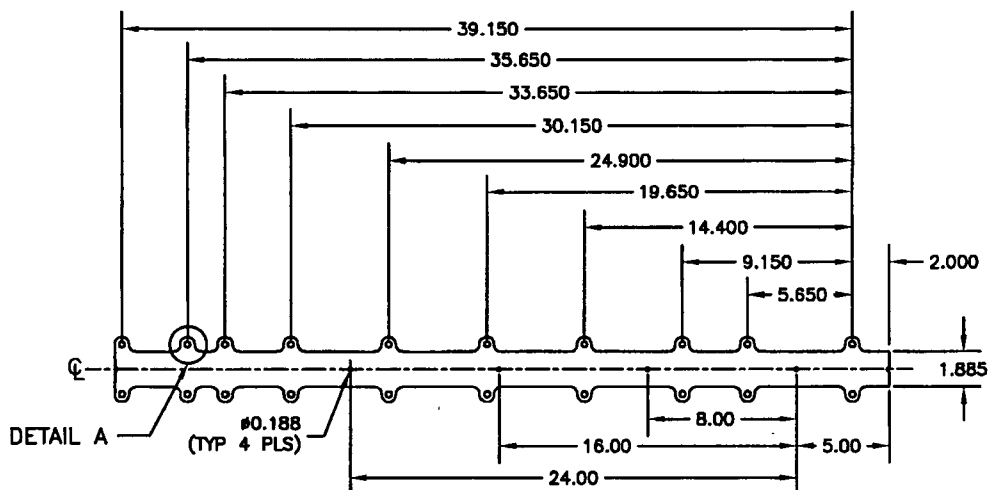
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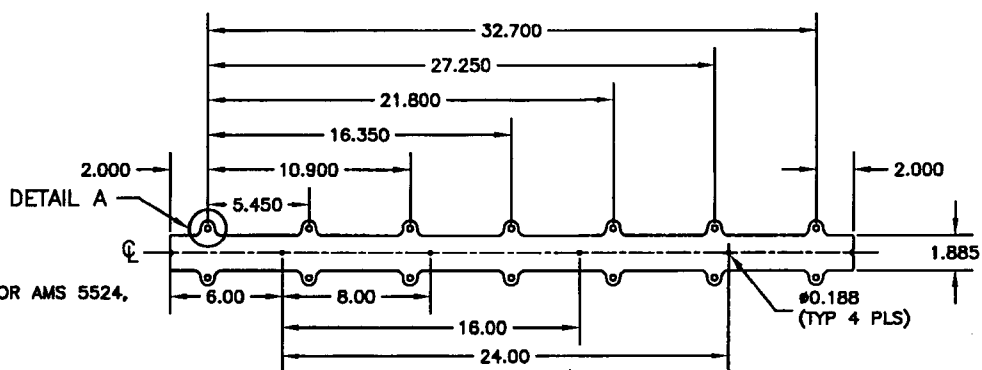
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#	#	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15F FLAT PATTERN**

DETAIL B

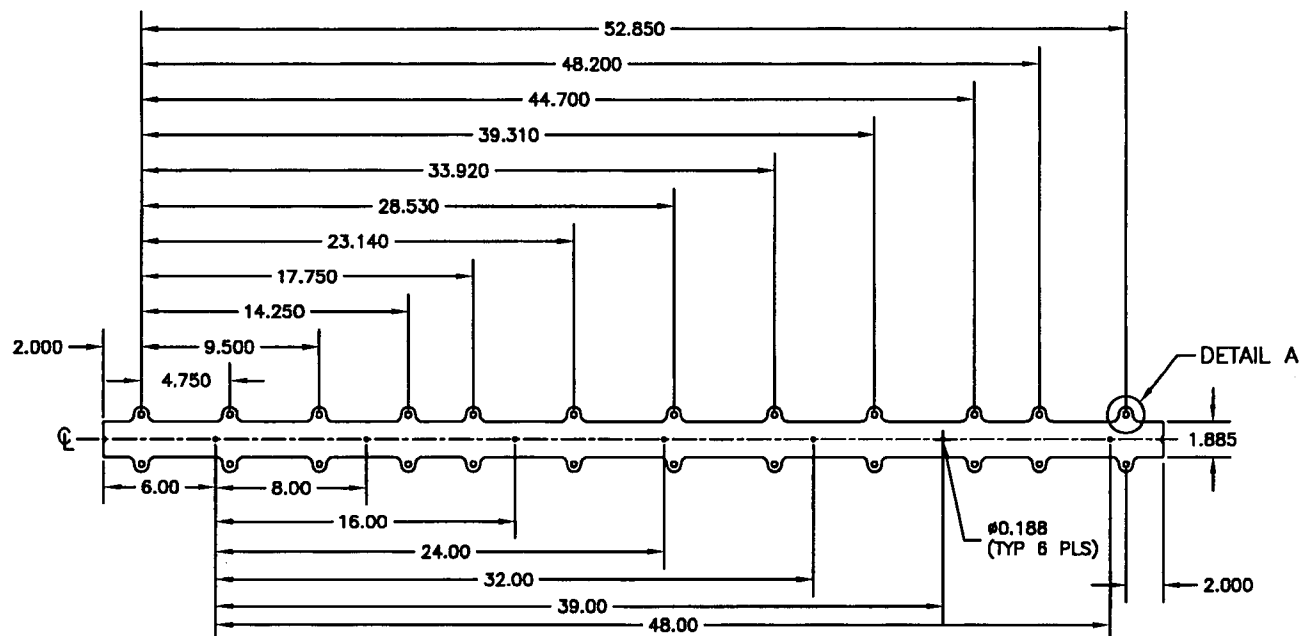
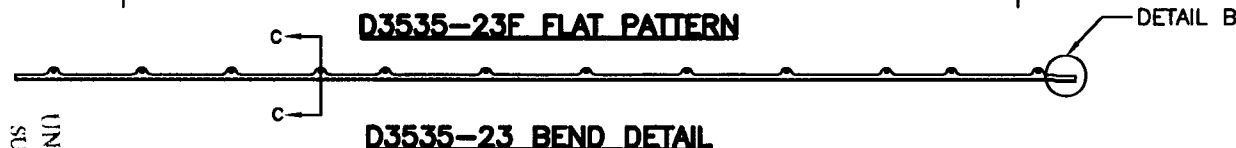
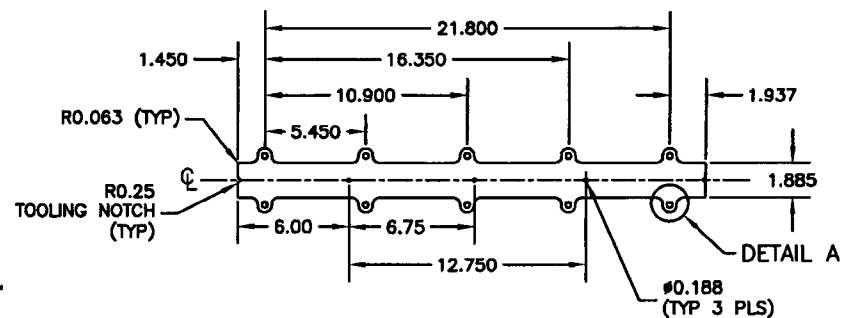
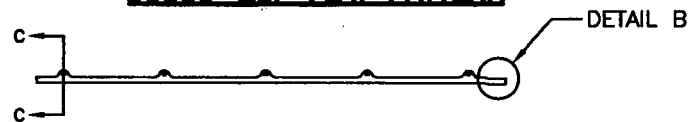
D3535-15 BEND DETAIL**D3535-21F FLAT PATTERN**

DETAIL B

D3535-21 BEND DETAIL

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NO. 41525

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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07.04.24**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

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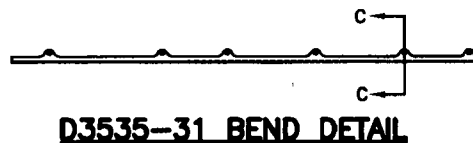
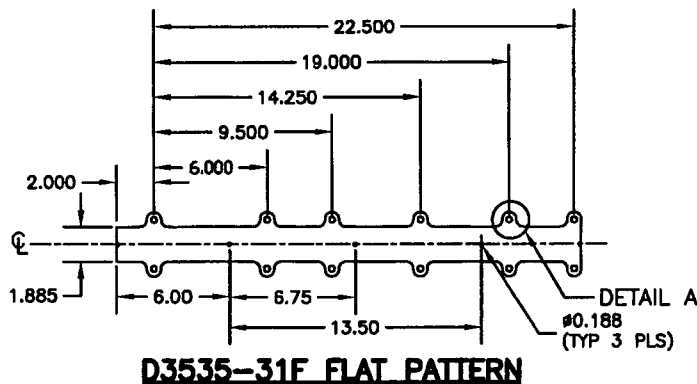
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DATE	TITLE	WEARSHOE
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	SHEET 3 OF 7	REV. B

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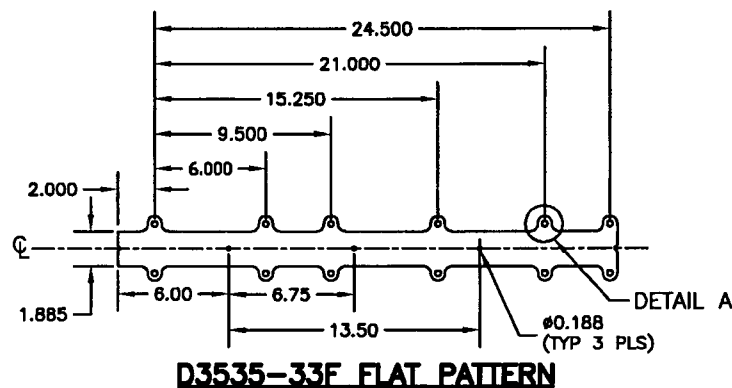
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
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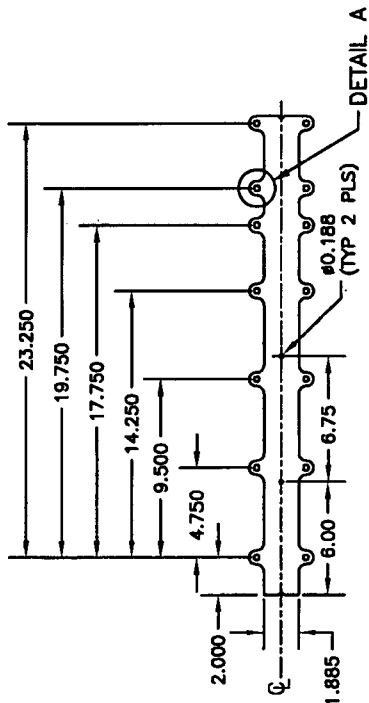
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07.04.17	WEARSHOE	SHEET 4 OF 7
		SCALE 1:10



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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10

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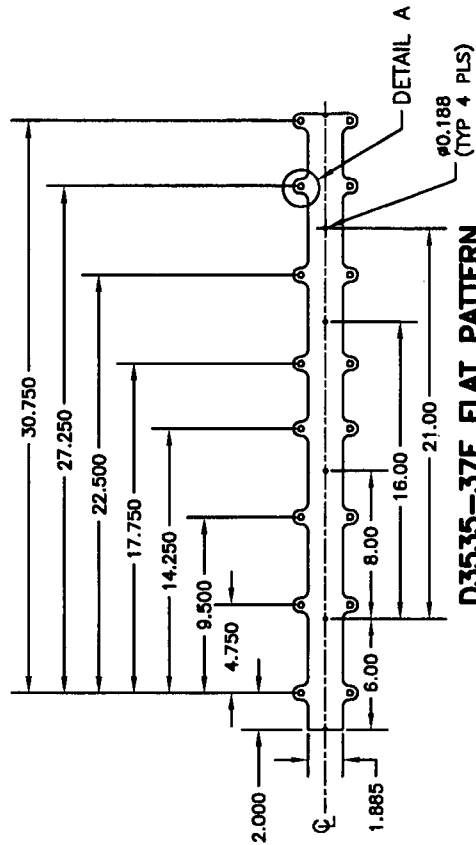


D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

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D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

- NOTES**
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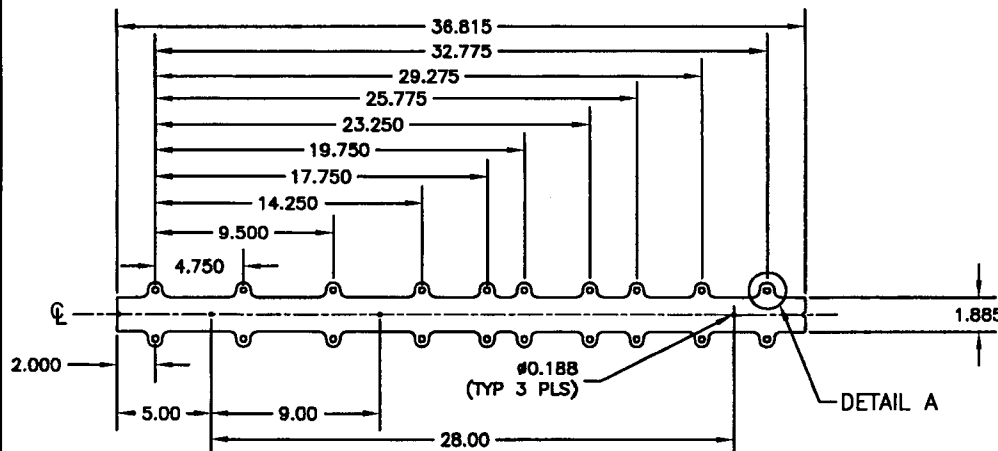
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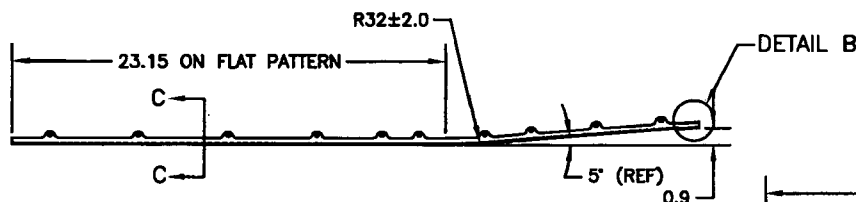
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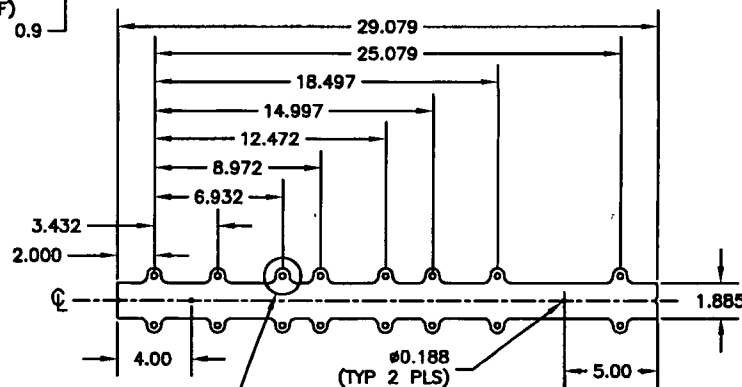
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



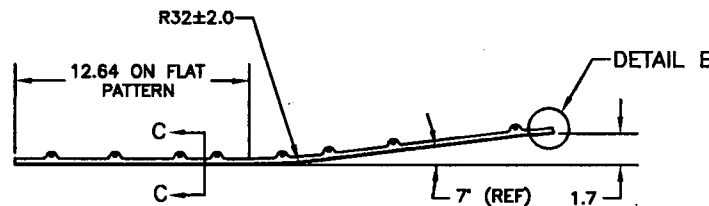
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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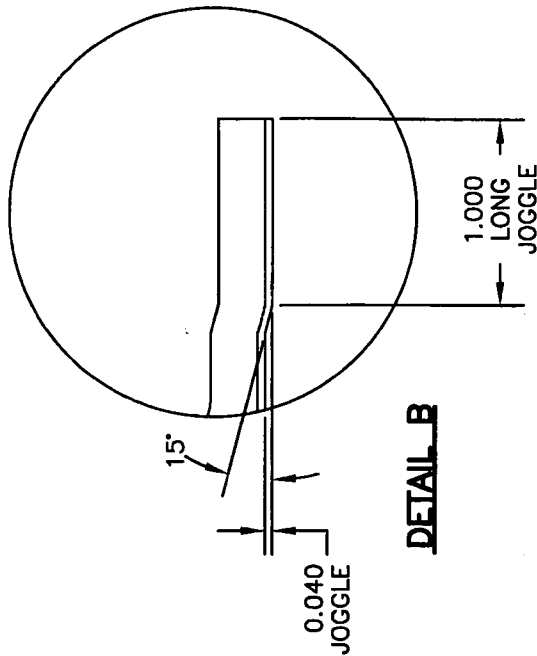
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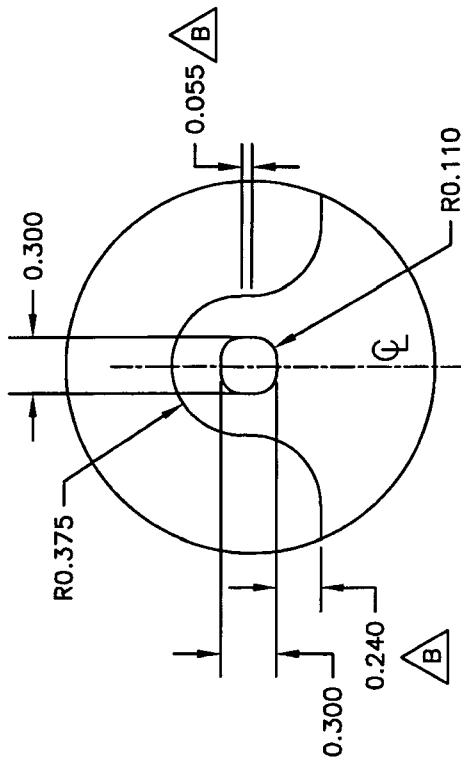


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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

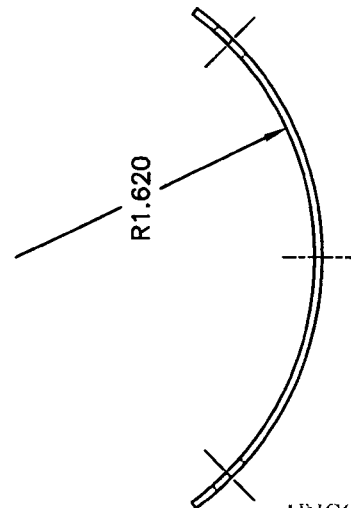
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DETAIL B



DETAIL A



SECTION C-C

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